

Rush Sent Jan 3, 2017

Work Order ID 154518

154518

Page 1

Thursday, December 15, 2016 8:00:41 AM

Item ID: D3876-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Protector - Door
 Start Date: 12/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/15/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: DEC 15 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr							DAS	
D3876	A							46	
								9-89	16/12/21
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.04							
FLOW CNC Waterjet	1-Cut as per Dwg D3876								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00						DAS	
110								46	
QC	Memo	0.00						9-89	16/12/21
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120								DAS	
QC	Memo	0.00						9	
Quality Control								9-89	① 12.02.06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																
Large Fab ☐	Composite ☐	Supplier ☐																																																																	
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																															
Description Work Order Deviation		Disposition		Completed By																																																															
				Lead hand / Supervisor Approval Verification																																																															
				QC / QA Coordinator Approval																																																															
Root Cause		FAULT CATEGORY																																																																	
<table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table>	Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width:100%; border: none;"> <tr><td style="border: none;">Pressure/Forced ☐</td><td style="border: none;">Temperature/Cure ☐</td></tr> <tr><td style="border: none;">Bending ☐</td><td style="border: none;">Set-up ☐</td></tr> <tr><td style="border: none;">Centre Not Concentric ☐</td><td style="border: none;">BOM/Route ☐</td></tr> <tr><td style="border: none;">Cracks ☐</td><td style="border: none;">Broken/Damage/Defect ☐</td></tr> <tr><td style="border: none;">Crimp/Kink/Ripple/Wave ☐</td><td style="border: none;">Inspection Incomplete/Unqualified ☐</td></tr> <tr><td style="border: none;">Cuffs ☐</td><td style="border: none;">Contamination ☐</td></tr> <tr><td style="border: none;">Crushing ☐</td><td style="border: none;">Countersink ☐</td></tr> <tr><td style="border: none;">Heat Treat ☐</td><td style="border: none;">Cut Too Short ☐</td></tr> <tr><td style="border: none;">Wave/Twist in Tube ☐</td><td style="border: none;">Instructions Incomplete/Unclear ☐</td></tr> <tr><td style="border: none;">Marks/Chatter ☐</td><td style="border: none;">Drill Holes ☐</td></tr> </table>	Pressure/Forced ☐	Temperature/Cure ☐	Bending ☐	Set-up ☐	Centre Not Concentric ☐	BOM/Route ☐	Cracks ☐	Broken/Damage/Defect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Cuffs ☐	Contamination ☐	Crushing ☐	Countersink ☐	Heat Treat ☐	Cut Too Short ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Marks/Chatter ☐	Drill Holes ☐	<table style="width:100%; border: none;"> <tr><td style="border: none;">Power Loss/Surge ☐</td><td style="border: none;">Positioned Wrong ☐</td></tr> <tr><td style="border: none;">Folio/Program ☐</td><td style="border: none;">Outside Dimensions ☐</td></tr> <tr><td style="border: none;">Grain ☐</td><td style="border: none;">Over/Under tolerance ☐</td></tr> <tr><td style="border: none;">Weld ☐</td><td style="border: none;">Part Incorrect ☐</td></tr> <tr><td style="border: none;">Wrong Stock Pulled ☐</td><td style="border: none;">Part Lost/Missing ☐</td></tr> <tr><td style="border: none;">Out of Sequence ☐</td><td style="border: none;">Part Moved ☐</td></tr> <tr><td style="border: none;">Off-set ☐</td><td style="border: none;">Drawing ☐</td></tr> <tr><td style="border: none;">Mislabeled ☐</td><td style="border: none;">Finish ☐</td></tr> <tr><td style="border: none;">Fit/Function ☐</td><td style="border: none;">Misread ☐</td></tr> <tr><td style="border: none;">Misaligned/off center ☐</td><td style="border: none;">Turning Sequence ☐</td></tr> </table>		Power Loss/Surge ☐	Positioned Wrong ☐	Folio/Program ☐	Outside Dimensions ☐	Grain ☐	Over/Under tolerance ☐	Weld ☐	Part Incorrect ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Out of Sequence ☐	Part Moved ☐	Off-set ☐	Drawing ☐	Mislabeled ☐	Finish ☐	Fit/Function ☐	Misread ☐	Misaligned/off center ☐	Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																																		
Design ☐	Operator ☐																																																																		
Doc/Data ☐	Offset/Setup ☐																																																																		
Equip/Tooling ☐	Supplier ☐																																																																		
Handling/Pre ☐	Training ☐																																																																		
Material ☐	Use for Testing ☐																																																																		
Internal Transport ☐	Poor Information ☐																																																																		
Tribal Knowledge ☐	Rushing ☐																																																																		
LOA ☐	Product Improvement ☐																																																																		
Substation ☐	Process Improvement ☐																																																																		
Past Expiry Date ☐	Manufacturing Process ☐																																																																		
Misidentified ☐	Past Due ☐																																																																		
Pressure/Forced ☐	Temperature/Cure ☐																																																																		
Bending ☐	Set-up ☐																																																																		
Centre Not Concentric ☐	BOM/Route ☐																																																																		
Cracks ☐	Broken/Damage/Defect ☐																																																																		
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐																																																																		
Cuffs ☐	Contamination ☐																																																																		
Crushing ☐	Countersink ☐																																																																		
Heat Treat ☐	Cut Too Short ☐																																																																		
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐																																																																		
Marks/Chatter ☐	Drill Holes ☐																																																																		
Power Loss/Surge ☐	Positioned Wrong ☐																																																																		
Folio/Program ☐	Outside Dimensions ☐																																																																		
Grain ☐	Over/Under tolerance ☐																																																																		
Weld ☐	Part Incorrect ☐																																																																		
Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																		
Out of Sequence ☐	Part Moved ☐																																																																		
Off-set ☐	Drawing ☐																																																																		
Mislabeled ☐	Finish ☐																																																																		
Fit/Function ☐	Misread ☐																																																																		
Misaligned/off center ☐	Turning Sequence ☐																																																																		
OTHER : _____																																																																			

Work Order ID 154518

Thursday, December 15, 2016 8:00:41 AM

154518

Page 2

Item ID: D3876-13 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Protector - Door
Start Date: 12/12/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>PK</u>	0.00				DAS 6 9-89			
130					DAS 6 9-89				
Packaging	Memo	0.00							
Packaging									
									JAN 03 2017
140	QC21- Final Inspection - Work Order Release	0.00							
140						DAS 21 9-89			JAN 06 2017
QC	Memo	0.02							
Quality Control									
									JAN 03 2017
						DAS 21 9-89			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, December 15, 2016 8:00:41 AM

Page 1

Work Order ID: 154518

154518

Parent Item: D3876-13

D3876-13

Parent Item Name: Protector - Door

Start Date: 12/12/2016

Required Date: 12/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09.01.23 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	4,547.982	3.31	3.894118			
MI FXS 125-F60029-04									**			DAS 46 9-89	16/12/21
GE PLASTICS LEXAN SHEET (DARK GREY)													

Location

Loc Qty

Loc Code

MAT018

4547.982353

m135074

803.482353

m136228

3744.5

3.8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

